

Date: Thursday, 14/08/2008 8:24:44 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	COVER PLATE	
Job Number	41226			Part Number	D37053	
Estimate Number	13165			Drawing Number	D3705 U/R Rev B 08-08-14	
P.O. Number				Project Number	N/A	
This Issue	14/08/2008	S.O. No.		Drawing Revision	U/R	
Prshrt Rev.	NC			Material		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	15/08/2008	Qty: 2 Um: Each
Previous Run	37294					
Written By						
Checked & Approved By	<u>MF 08-08-14</u>					
Comment	Est Rev:A 08-01-30 new issue EC verified by:DD					

## Additional Product



Job Number:



**PRELIMINARY ISSUE** 08-08-14

Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.7466 sf(s)/Unit Total : 1.4931 sf(s) 6061T6 aluminium sheet .080" thick (M6061T6S080) Batch: <u>108433</u>	 <b>FOR ENGINEERING USE ONLY</b> <del>PROTOTYPE</del>
2.0	WATER JET	FLOW WATER JET	  <b>2</b>
		Comment: FLOW WATER JET 1-Cut as per Dwg D3705 Dwg Rev: <u>PRF</u> Prog Rev: <u>PRF</u> ***grain direction along 26.57*** 2- Deburr if necessary	 <u>HB 8-8-14</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <u>13 8-8-14</u>
4.0	QC8	SECOND CHECK	 <u>108-08-15</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	  <u>B 08-08-14</u>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Counter sink as per day 2- BEND AS PER DWG D3705	

Date: Thursday, 14/08/2008 8:24:44 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: COVER PLATE
Job Number: 41226		Part Number: D37053
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5 	INSPECT WORK TO CURRENT STEP <b>ENGINEERING APPROVAL</b> 08-08-18 JH BFB
Comment: INSPECT WORK TO CURRENT STEP		
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WS		FOR ENGINEERING USE ONLY 08-08-18 (2)
8.0	QC21 	FINAL INSPECTION/W/O RELEASE 09/02/18 JH
Comment: FINAL INSPECTION/W/O RELEASE		10.08.22 Pemone
Job Completion 		
<p>0024A      u 09.02.18</p> <p>POSITIVE RECALL EFFECTIVE 08.08.22 AUTH RELEASED 08.08.22 DATE 09.02.18</p>		

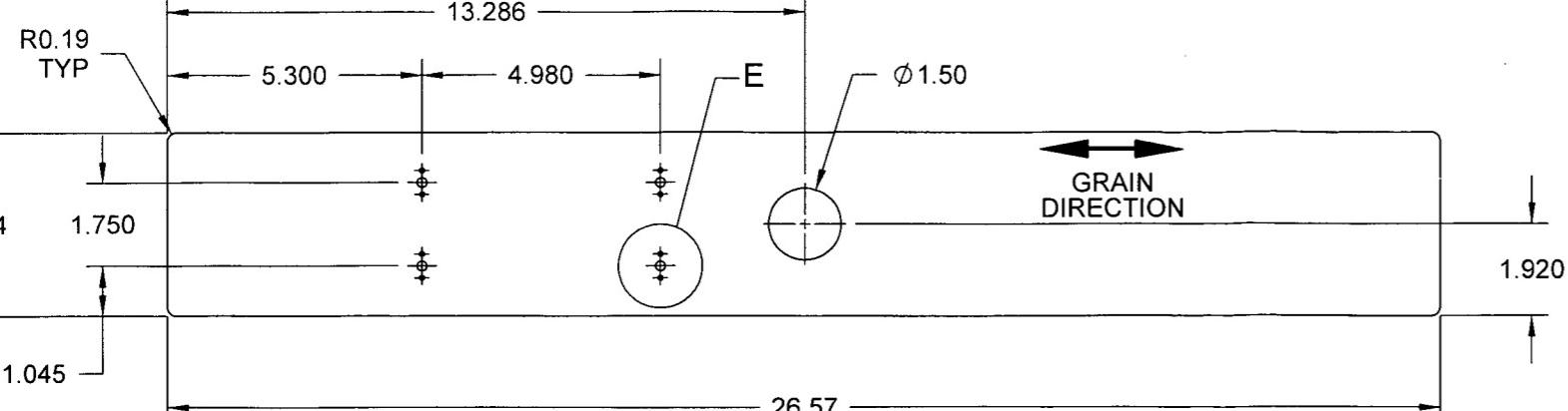
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	41226
<b>Description:</b>	COVER PLATE	<b>Part Number:</b>
Inspection Dwg:	D3705-3 Rev: W/R	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

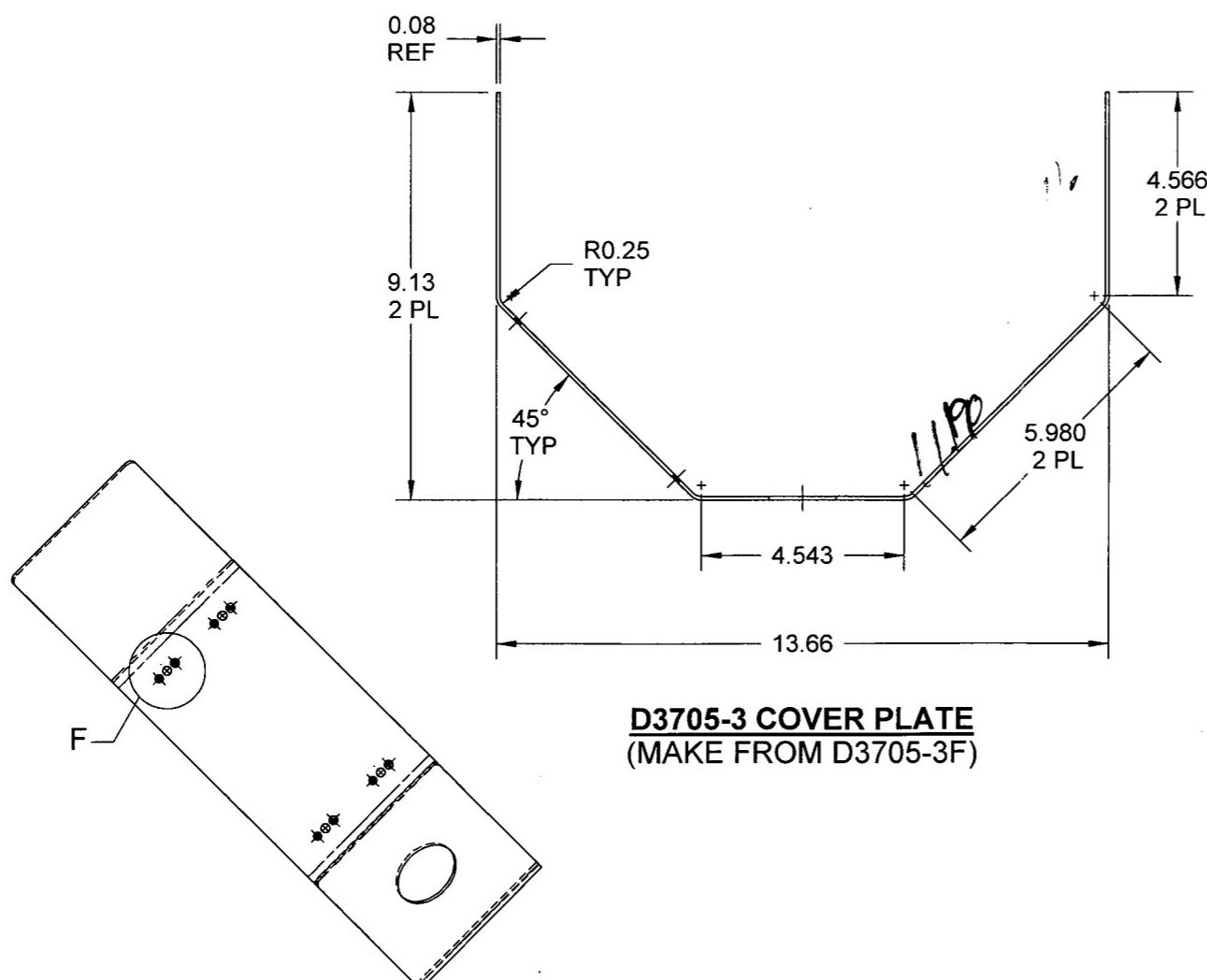
## X First Article      Prototype

<b>Measured by:</b>	<b>Audited by:</b>	<b>Prototype Approval:</b>
<b>Date:</b> 8-8-14	<b>Date:</b> 10/08/15	<b>Date:</b> N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	



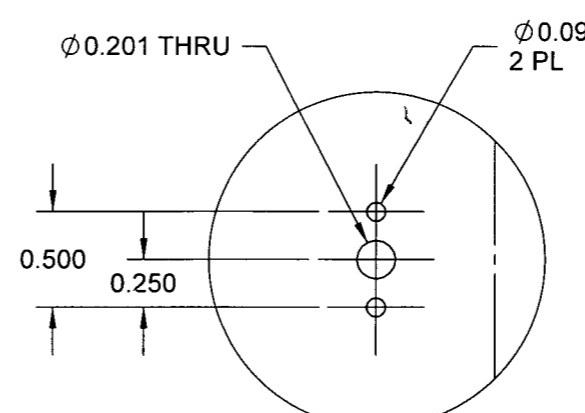
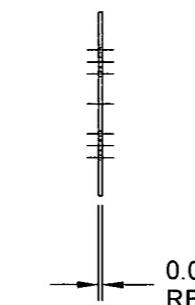
**D3705-3F COVER PLATE FLAT PATTERN**



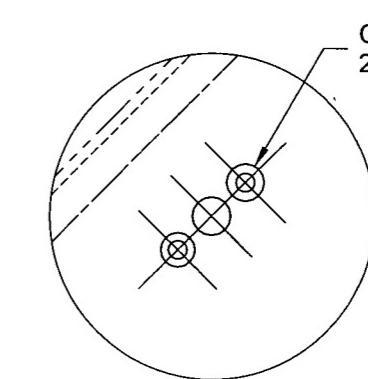
**D3705-3 COVER PLATE  
(MAKE FROM D3705-3F)**

**D3705-3-3F NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs



**DETAIL E**  
SCALE 4X  
4 PL



**DETAIL F**  
SCALE 4X  
4 PL

**PRELIMINARY ISSUE**

08.08.22

**PROTOTYPE**

08.08.14

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	—	HAWKSLEY, ONTARIO, CANADA
CHECKED	—	DRAWING NO.
MFG. APPR.	—	D3705
APPROVED	—	REV. B
DE APPR.	—	SHEET 4 OF 5
DATE	08.08.07	SCALE
		NTS
		<b>INSTRUMENT PANEL ASS'Y</b>
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		NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
		WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Thursday, 14/08/2008 8:24:44 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: COVER PLATE		
Job Number	: 41226					
Estimate Number	: 13165					
P.O. Number	:			Part Number	: D37053	
This Issue	: 14/08/2008		S.O. No. :	Drawing Number	: D3705 U/R	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	: U/R	
Previous Run	: 37294			Material	:	
Written By	:			Due Date	: 15/08/2008	
Checked & Approved By	: MT 08-08-14			Qty:	2 Um: Each	
Comment	: Est Rev:A 08-01-30 new issue EC verified by:DD					

## Additional Product

## REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Copper thys (P/O: 6623)



Comment: Qty.: 0.7466 sf(s)/Unit Total : 1.4931 sf(s)

.6061T6 aluminium sheet .080" thick ,

(M6061T6S080)

Batch: 108433

HB 8-8-14

FOR ENGINEERING USE ONLY

PROTOTYPE

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: PPF

Prog Rev: PPF

HB 8-8-14

2

\*\*\*grain direction along 26.57\*\*\*

2- Deburr if necessary

HB 8-8-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-8-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



SECOND CHECK

108-08-15 2

Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Counter sinks as per day

2- BEND AS PER DWG D3705

S 08-08-14 2

# Receiving Report

Date: 8/4/05Batch No: M108433Supplier: FUYSOKRUPPDart P/O: 6623

Packing Slip: Yes  No   
 Invoice: Yes  No   
 Receipt: Cash  Cr

Release Note Attached: Yes  No  N/A   
 Waybill Attached: Yes  No  N/A   
 Shipment Complete: Yes  No  N/A   
 QC6 Inspection NDI  N/A   
 Work Order A26628  N/A

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 CL

Production/Admin:

Date 08/06/05Received/Costing RCP 8231Initial CG

Location \_\_\_\_\_

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

7:30 AM TO 5:00 PM MONDAY TO FRIDAY

\*\*\* CUSTOMER PICK-UP HOURS \*\*\*

\*\*\* 9:00 AM TO 4:00 PM \*\*\*

\*\*\*\*\* WE STOCK STAINLESS STEEL!!!! \*\*\*\*\*

\*\*\*\*\* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT \*\*\*\*\*

**RECEIVED JUL 02 2008****NOTE:**

Nouvelle adresse de remise de paiement.  
 Veuillez s.v.p. indiquer le(s) numéros  
 de fracture(s) correspondante(s)

**NOTE:**

Our new remit to address  
 Please indicate invoice number(s) on all remittances.

Material	Processing	Freight	Other	Taxes	TOTAL DUE
----------	------------	---------	-------	-------	-----------

762.24

38.11 800.35

Taxes: GST/SAL	38.11	0.00		
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Page: 1 .... Last

## THYSSENKRUPP MATERIALS NA

## Certificate of Mill Test Results

BL\_PEC-000000-000

Pg 1/2

PART NO.

PO/Ref

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

Signed by \_\_\_\_\_

Amit CHANTAL @ DART AERO

DOC : V/0080240236

DATE : 2007-06-25

PROD. REF. : 0000221825/001

NRBST : 08129/01

PAGE : 1 / 2

INSPECTION CERTIFICATE



Aleris Aluminum Duffel BVBA  
A. Stockdaan 87, 2570 Oostduinkerke - Belgium

CUSTOMER : ALERIS ALUMINUM US SALES INC.

08/06/08

YOUR ORDER NUMBER : PO9277 (CHARLESTON PO#5186-E)  
 OUR ORDER NUMBER : 08129/01  
 DOCUMENT NUMBER : V/0080240236

DESCRIPTION : ALU SHEETS (STEN) AA 6061-T6 AMS-QQA 250/11 ANS 4027M ASTM B209-04  
 DIMENSIONS : 144" X 48" X .08"  
 ARTICLE NO. :

COIL  
NUMBER

CAST  
NUMBER

## CHEMICAL COMPOSITION (%)

001 1643381

	Si	Pb	Cu	Mn	Mg	Cr	Ti	Zn
MIN	0,40	0,15	0,15	0,15	0,8	0,04		
MAX	0,8	0,7	0,40		1,2	0,35	0,15	0,25
	0,63	0,4	0,20	0,08	1,0	0,15	0,02	0,02

OTHERS : EACH TOTAL : MIN MIN 0,05 MAX  
 TOTAL : MIN MIN 0,15 MAX

TEST-  
NUMBER

## MECHANICAL PROPERTIES

(T) = TRANSVERSAL (L) = LONGITUDINAL

1 N/MM<sup>2</sup> = 1 MPa = 0,1 HBAR = 0,102 KG/MM<sup>2</sup> = 0,145 KSI

/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

MIN  
MAX

RM  
KSI

R002  
KSI

A

001 /A

40

16

001 /M

48

16

001 /V

48

17

SEP-21-2007 07:55AM FROM CHARLESTON ALUMINUM 80359357179

TO:19857339033

10  
14

Charleston Aluminum LLC  
 480 Frontage Rd.  
 Gaston, SC 29053

Aleris Aluminum Duffel BVBA

Indexed 26Sep07 by anand

# THYSSENKRUPP MATERIALS NA

## Certificate of Mill Test Results

BL\_PEC-000000-000

PART NO:

PO/Ref

We certify that this is a true copy of the report  
furnished by the producer of the metal, or data  
resulting from tests made in approved labs.

Signed by:

Alt: CHANTAL @ DART AERO

Pg 2/2

DOC : V/0080240236

DATE : 2007-06-25

PROD. REP. : 0000221825/001

NRBST : 08129/01

PAGE : 2 / 2



Aleris Aluminum Duffel BVBA  
A. Stocklaan 67, 2570 Duffel - Belgium

DATE SOLUTION HEAT TREATEMENT COIL NUMBER  
001 STENCILLING : WEEK 24 / YEAR 2007

HEAD OF LABORATORY,  
XAVIER SCHELTIJENS

A handwritten signature in black ink, appearing to read "Xavier Scheltjens".

Charleston Aluminum LLC  
480 Frontage Rd.  
Gaston, SC 29053

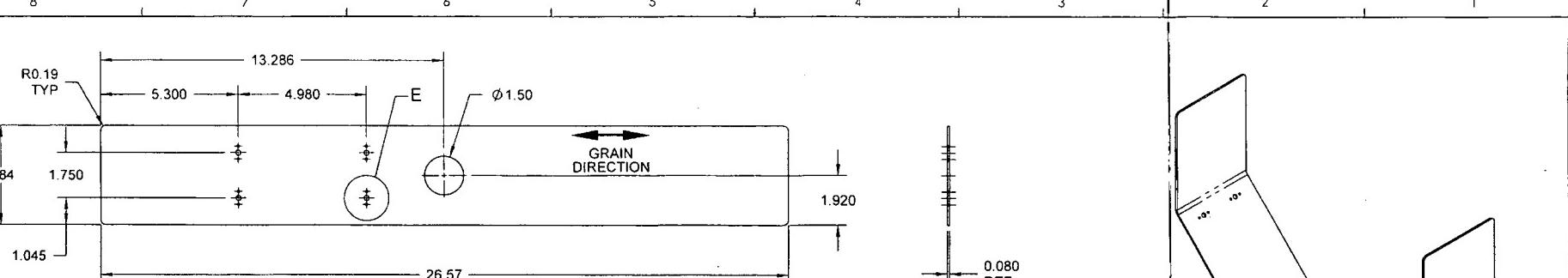
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TO:19257389023

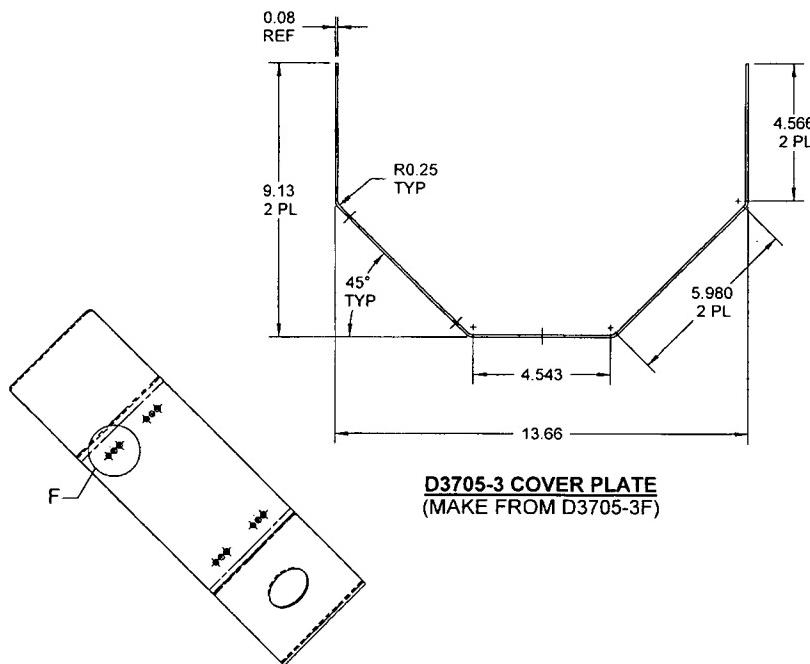
P.6

Aleris Aluminum Duffel BVBA

Indexed 26Sep07 by anand



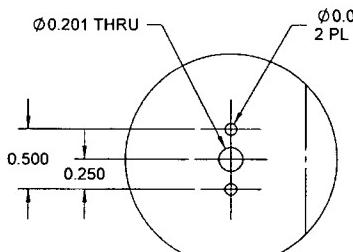
**D3705-3F COVER PLATE FLAT PATTERN**



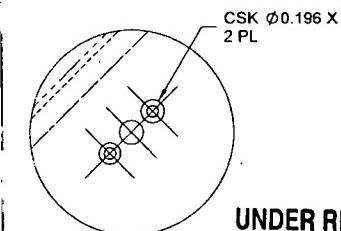
**D3705-3 COVER PLATE  
(MAKE FROM D3705-3F)**

**D3705-3/-3F NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs



**DETAIL E**  
SCALE 4X  
4 PL



**UNDER REVIEW**

08.01.14 A

**RELEASED**  
09/01/14 10:00

DESIGN	1/12/14	DART AEROSPACE LTD
DRAWN	1/12/14	HAWKSLEY, ONTARIO, CANADA
CHECKED	1/12/14	REV. B
MFG. APPR.	1/12/14	SHEET 4 OF 5
APPROVED	1/12/14	SCALE
DE APPR.	1/12/14	NTS
DATE	08.08.07	INSTRUMENT PANEL ASS'Y

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